

Work Order ID 108059

October-08-13 10:45:14 AM

108059

Page 1

Item ID: D4021-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hoop
 Start Date: 10/07/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/21/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-10-08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4021	B								
100		0.00							
100									
Waterjet		0.00							
FLOW CNC Waterjet									
304, 625" x 3"									
	Memo								
	Cut as per dwg D4021								
	Prog Rev: <u>3</u>								
	Dwg Rev: <u>B</u>								
	Deburr as required								
110		0.00							
110									
QC		0.00							
Quality Control	Memo								

28 0 Ac
13.10.10

28 0 Ac
13.10.10

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 9-89 0.00 13 10 H				28 Count			
130 *130* Small Fab Small Fab	Memo 1- make radius as per dwg 2- deburr	0.00 0.00							(28) CC 13-10-16
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				28x			13-10-16 Cpl

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pl 13-10-17

Picklist Print

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Page 1

Work Order ID: 108059

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Parent Item: D4021-7

D4021-7

Parent Item Name: Hoop

Start Date: 10/07/13

Required Date: 10/21/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.625X3.000

Purchased

No

100

f

23.2000

0.4166

9

M304B0 625X3 000

**

Jm 13-10-09

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT049

23.2

m126779

10

m127015

13.2

126779 → 12.6

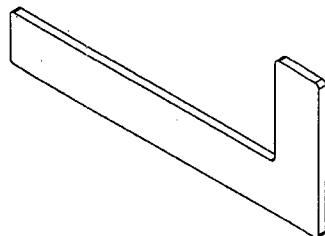
DART AEROSPACE LTD		Work Order:	108059
Description: Hoop		Part Number:	D4021-7
Inspection Dwg: D4021 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

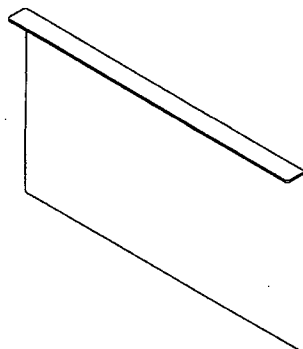
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Measured by: Jm	Audited by: 27 9-89	Preliminary Approval: N/A
Date: 13-10-09	Date: 13-10-11	Date: N/A

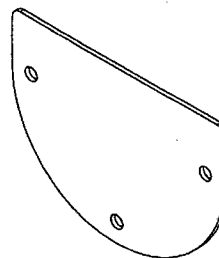
Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.18	Dimensions revised per Dwg Rev B	KJ	



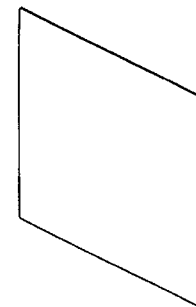
D4021-1 HANDLE PLATE



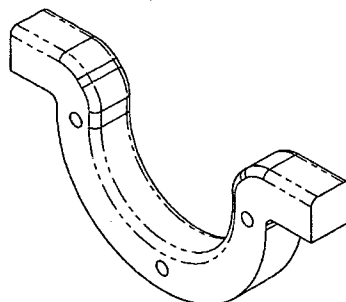
D4021-3 DATA PLATE



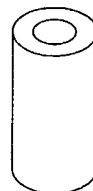
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



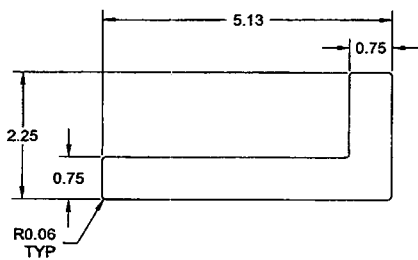
D4021-9 BUSHING

108059 MLJ
13-10-08

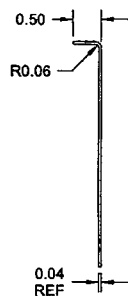
RELEASED
2010-04-14
MP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

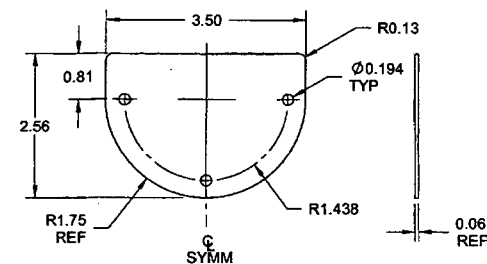
108059



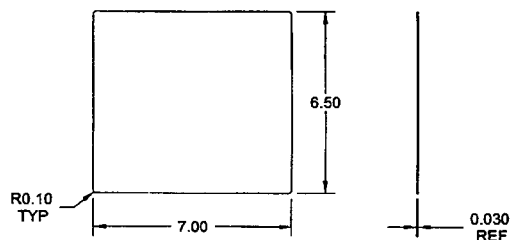
D4021-1 HANDLE PLATE



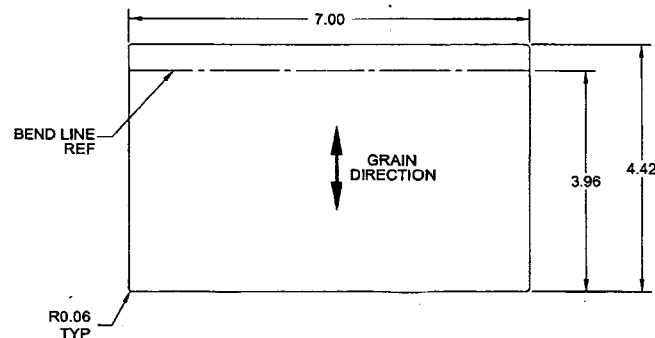
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

NOTES:

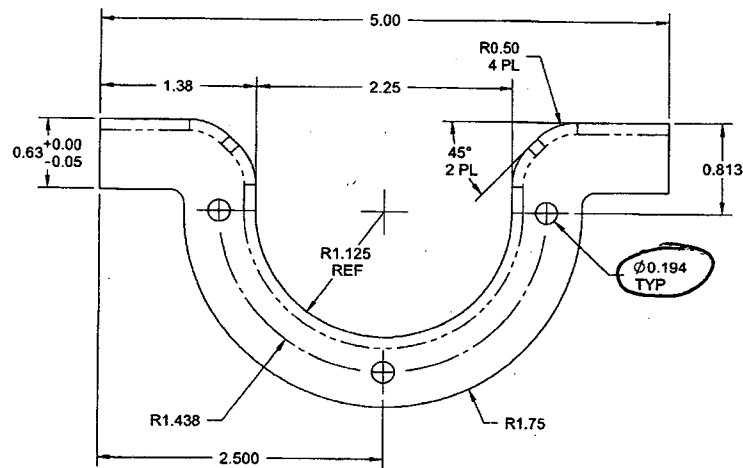
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH : -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs

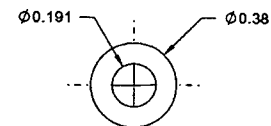
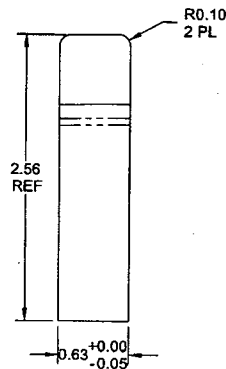
RELEASED
R 2010-04-11
NIP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

108059



D4021-7 HOOP



D4021-9 BUSHING

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

RELEASED
2010-04-14

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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